

Work Order ID 51425

Page 1

August 24, 2009 10:26:40 AM

Item ID: D2274

Accept



Setup Start



Revision ID: F

Stop



Item Name: Radius Block

Start Date: 24/08/2009 Start Qty: 300.00



Cust Item ID:

Required Date: 28/08/2009 Req'd Qty: 300.00



Customer:

Reference:

24/08/2009

Run Start



Approvals: Process Plan:

Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2274	Rev F

100



SHEAR

0.00

8/09/08/24

324

Shear

Memo

0.00

blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces

110



HAAS CNC VERTICAL MACHINING #1

0.00

Jawf
8/09/08/24

324

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per folio D2274

120



QC2- Inspect parts off machine FAI/FAIB

0.00

mk 09/08/25

324

QC

Memo

0.00

Quality Control

Work Order ID 51425

August 24, 2009 10:26:40 AM



Page 2

Item ID: D2274

Accept



Setup Start



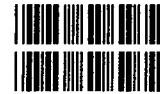
Revision ID: F

Stop



Item Name: Radius Block

Start Date: 24/08/2009 Start Qty: 300.00



Cust Item ID:

Required Date: 28/08/2009 Req'd Qty: 300.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC8- Inspect parts - second check

0.00

M.A 09/08/25

324



QC

Quality Control

140



Small Fab

0.00

m-f 09/09/01

324X

B9-9-2

Small Fab

Small Fab

Memo

0.00

Tumble□Deburr any rough edges after tumbling

150



Chemical Conversion Coat per QSI005 4.1

0.00

MD 09/09/08

X324

HandFinish

Hand Finishing

0.00

Work Order ID 51425

August 24, 2009 10:26:40 AM



Page 3

Item ID: D2274

Accept



Setup Start



Revision ID: F

Stop



Item Name: Radius Block

Start Date: 24/08/2009 Start Qty: 300.00



Cust Item ID:

Required Date: 28/08/2009 Req'd Qty: 300.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

**Sequence ID/
Work Center ID**

160



QC

Quality Control

**Operation
Description**

QC3- Inspect Part Finish

Memo

**Set Up/
Run Hours**

0.00

0.00

**Draw
Number**

Bk 01-09- 9

**Draw
Rev.**

324

**Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

170



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

Aug/5/09 (324)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*09/09/09 (D)
MF 09-09-09*

Picklist Print

Page 1

August 24, 2009 10:26:40 AM

Work Order ID: 51425



Parent Item: D2274RevF



Parent Item Name: Radius Block

Start Date: 24/08/2009

Required Date: 28/08/2009

Comments:

Start Qty: 300.00

Required Qty: 300.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B00750X00.1 25		Purchased	No			100	f	91.9697	28.9263			

6061-T6 Bar .750 x .125



28/08/2009



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	91.9697	
104725	7.52	
105061	11.4	
109760	16.25	
110591	56.7997	28.9263

DART AEROSPACE LTD	Work Order:	51425
Description: Radius Block	Part Number:	D2274
Inspection Dwg: D2274 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<i>JmL</i>	Audited by:	<i>b.A</i>	Prototype Approval:	N/A
Date:	09/08/25	Date:	09/08/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF xx	FF

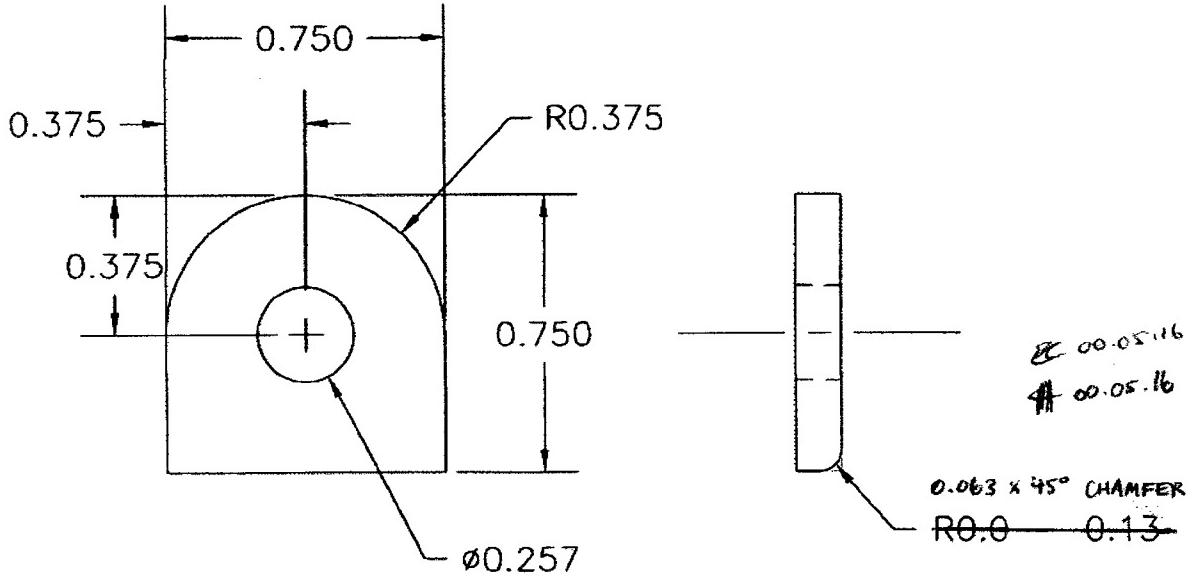
DART

DESIGN KE	DRAWN BY KF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MDY</i>	APPROVED <i>JS</i>	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11		TITLE RADIUS BLOCK	SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	

RELEASED

98/08/18 KE

a/b 51425



MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK
 OR 6061-T6 (QQ-A-250/11) 0.125 THICK

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED